

Work Order ID 51393

August 21, 2009 7:51:01 AM



Page 1

Item ID:	D3195-043	64	Accept		Setup	Start	
Revision ID:	A					Stop	
Item Name:	Bracket Assembly						
Start Date:	22/08/2009	Start Qty:	8.00		Cust Item ID:		
Required Date:	28/08/2009	Req'd Qty:	8.00		Customer:		
Reference:	<i>Inf 09.08.21</i>						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3195	Rev A								
100	BAND SAW	0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: (1.250" x 1.500") x 3.60" long								
				<i>inf 09/08/21</i>		<u>8</u>	<u>0</u>		
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3 2-Deburr								
				<i>N.A 09/08/21</i>		<u>8</u>	<u>0</u>		
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
				<i>N.A 09/08/21</i>		<u>8</u>	<u>0</u>		

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Item ID: D3195-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Assembly

Start Date: 22/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

ML 09/08/25

8

Ø

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

ML 09/08/25

8

Ø

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M109091

ML 09/08/26

8

Ø

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:30pm OVEN TEMPERATURE:
8:00pm FINISH TIME: 320°F

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Item ID:	D3195-043	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Bracket Assembly					
Start Date:	22/08/2009	Start Qty:	8.00	Cust Item ID:		
Required Date:	28/08/2009	Req'd Qty:	8.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR 09-08-26			(8)			
170 Small Fab Small Fab	Small Fab Memo 1-Lightly Sand bonding surface 2-Bond D3195-7 into D3195-13as per Dwg D3195 A/R Contact Cement 1109107	0.00 0.00							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 8 09/08/07			(78)			

9509/08/27 (8)

(78) /

Picklist Print

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Work Order ID: 51393



Parent Item: D3195-043RevA



Parent Item Name: Bracket Assembly

Start Date: 22/08/2009

Required Date: 28/08/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3195-7RevA

Manufactured

No

100

Each

6.0000

8.0000



Pad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

39337

6

M6061T6B1.500X01.25

Purchased

No

170

f

71.3200

2.5263

0



6061-T6 Bar 1.50 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

71.32

107461

11.84

110936

59.48

Ep 09/08/26
B51569 (2x)

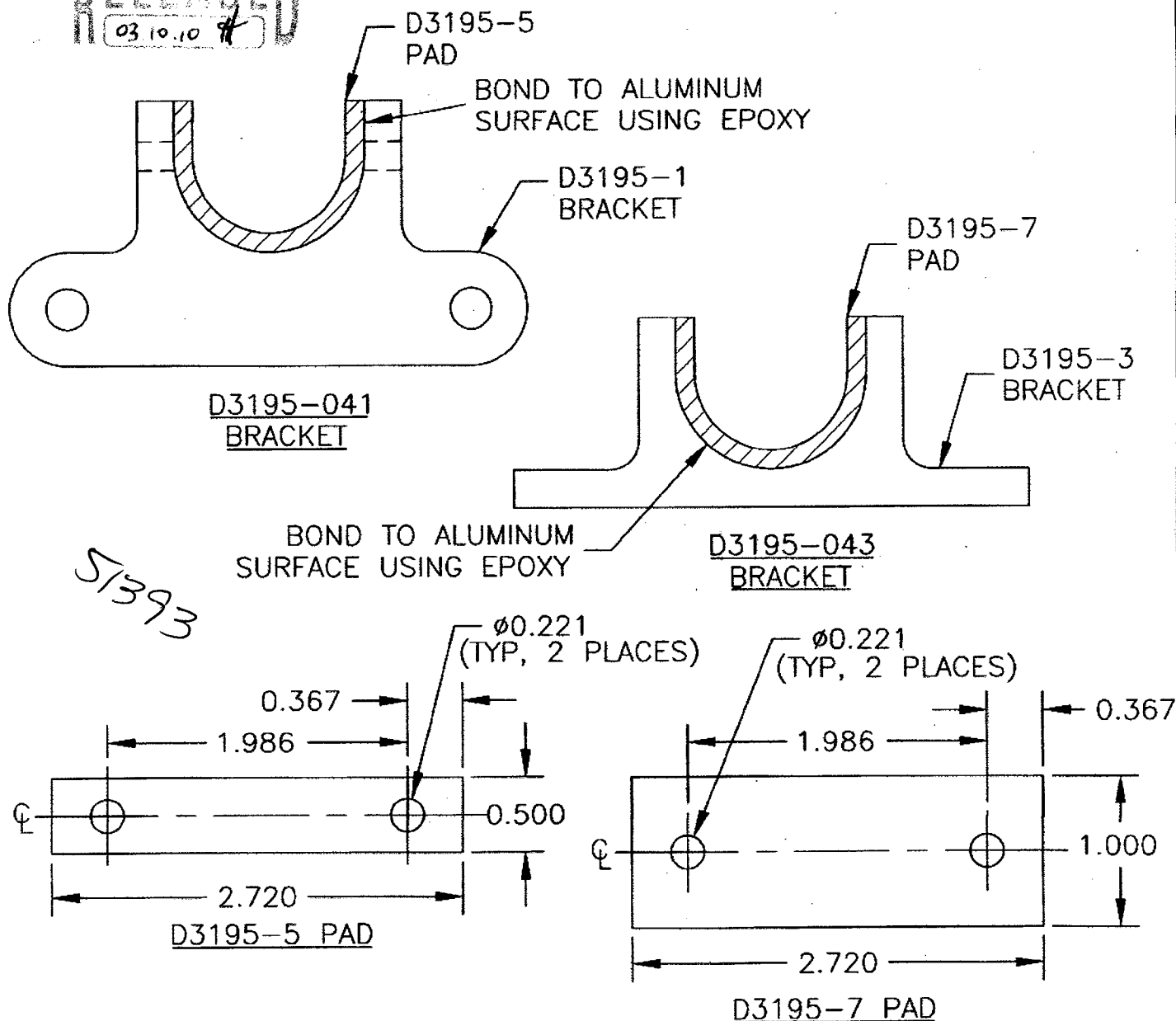
6

2.5263 *amt 04/08/21*



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE	03.06.23			TITLE BRACKET	SCALE 1:1
A	03.06.23			NEW ISSUE	

RELEASED
03.10.10



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

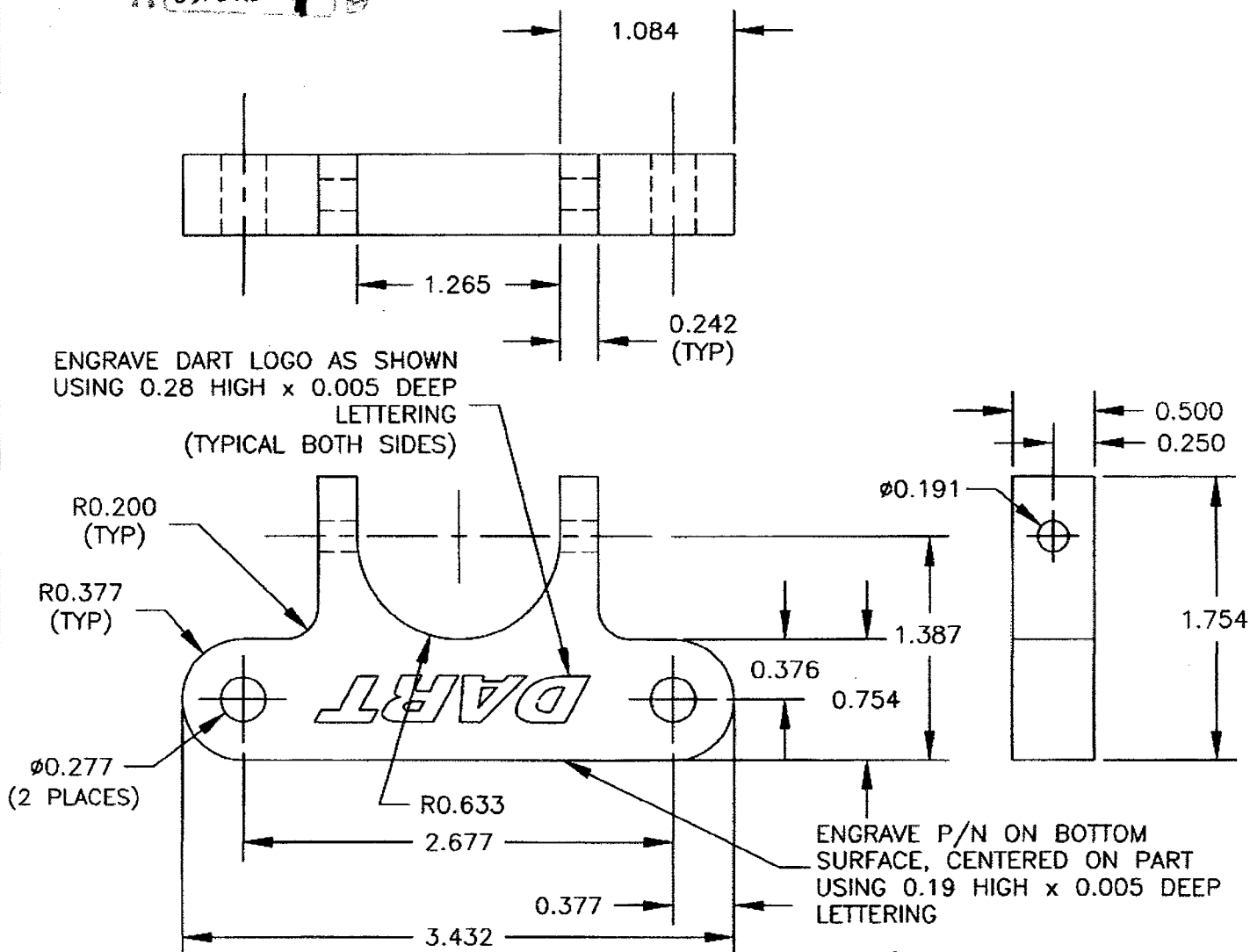
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



51393

D3195-1 BRACKET

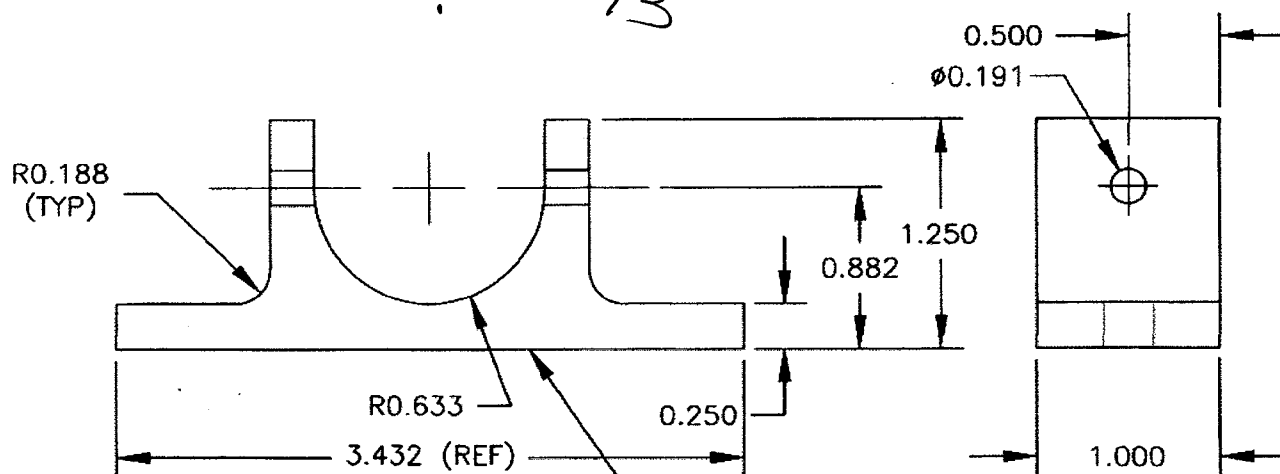
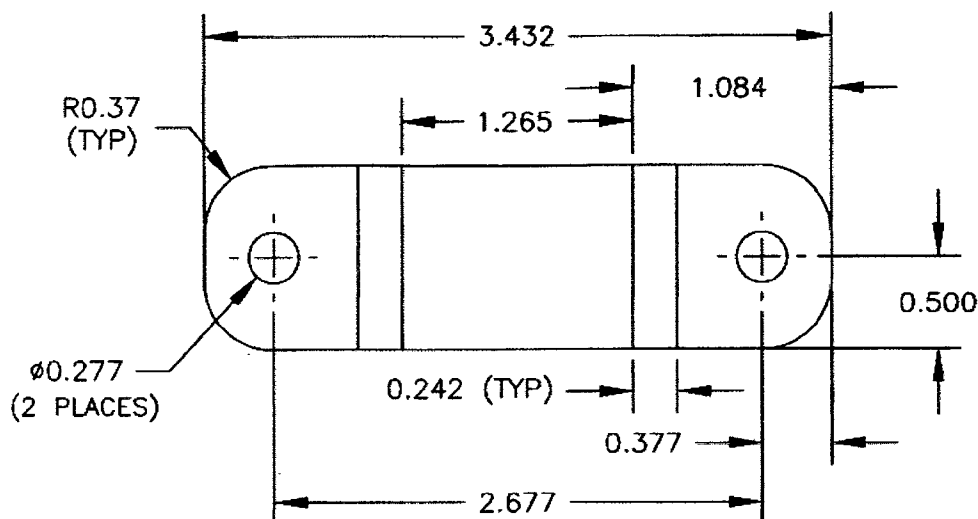
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



ENGRAVE P/N ON BOTTOM
SURFACE, CENTERED ON PART
USING 0.19 HIGH x 0.005 DEEP
LETTERING

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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